## Work Order ID 96829

\*96829\*

Ship March 25

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February-07-1.	3 8:22:47 Ai	M			100/	9			,	27		Page 1
Item ID: Revision ID: Item Name:	D3876-9 Protector - F	RH Afi Wall		Accept	*	N900	<u>040</u>	100	ገ*	Setup Sta	1.71	S1*
Start Date: Required Date Reference:	2/07/13	Start Qty: 12.00 Req'd Qty: 12.00	*12 *12			Cust Item I	D:				* ^N	S2*
Approvals:		lan: MCJ			······································		ate:	- 		Run Sta	1/1	R1* R2*
Sequence ID/ Work Center		Operation Description		Set Up Run H		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		evision Nbr				··· · · · - ·						
D3876  100  *100* Waterjet FLOW CNC Water	A rjet	FLOW WATER JET  Memo 1-Cut as per Dwg Rev:_ Prog Rev:_ 2- Deburr if	<u> </u>	0.00					(3	0		_Jm13-2-2
*110 *110* QC Quality Control		QC2- Inspect parts off m  Memo	achine FAI/FAIB	0.00					12	. 0	·	Jm13-2-2
120 *120* QC Quality Control		QC8- Inspect parts - seco	ond check	0.00	13205	ò			D		·	-

												DQA:	Dat	æ:	
NCR: Y	es	/ No				WORK ORDER NON-O	CON	<b>VFORM</b>	MANCE / UP	DATE					
										- Arana - · · · · · · · · · · · · · · · · · ·	_	QA Closed:	Dat	te:	·
Work Orde						DISPOSITION				AGAINST D	EP	ARTMENT/	PROCESS		
work Orde	-				<del> </del>	Rework	1		Skid-tube	Crosstube	٦		Water Jet		Engineering
Part N	lo.					Scrap	1 1		Machining	Small Fab	7	Proc	l. Eng. Coor.		Quality
	•					Use-as-is	1 1	Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	lo.					Work Order Update	]		Large Fab	Composite			Supplier		
							!			•••	<del></del>	C: 0		_	
Root	l	·			Desci	ription of work order update	1	nitial		tion	-	Sign &			06 12 22 22
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	-	Date	Verification		QC Inspector
Doc/Data															
Equip/Tooling															
Operator							l								
Material							•							ļ	
Setup											- [			ł	
Other											1				
Process															
Supplier															
Training							Ì				ļ				
Unapproved							L		<u> </u>		$\bot$				
FAULT CATEGORY															
Landi	Landing Gear General														
		Bending				Bend		Grain				Ovalized		$ldsymbol{ldsymbol{ldsymbol{eta}}}$	Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route	L	Hardware				Over/Under	tolerance	L	Temperature/Cure
	Cracks			Broken/Damaged		Inspection Incomplete				Part Incorrec	ct .	L	Weld		

Instructions Incomplete/Unclear

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Wrong Stock Pulled

Other

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

February-07-13 8:22:47 AM

Page 2

Item ID: D3876-9 Accept \*N900040100\* Setup Start Revision ID: Item Name: Protector - RH Aft Wall **Start Date:** 2/07/13 **Start Qty: 12.00** Cust Item ID: Required Date: 3/22/13 Req'd Qty: 12.00 **Customer:** Reference: Run Approvals: Process Plan: \_\_\_\_ Date: Tooling: Date: Stop Date: \_\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Qty Code Qty Number Stamp 130 Identify as per dwg & Stock Location:\_ 0.00 \*130\* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 \*140\* -D) MF 13-2-26 QC 0.00 Memo Quality Control

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Crosstube Water Jet Engineering Skid-tube Rework Prod. Eng. Coor. Quality Small Fab Machining Part No. Scrap Other Rec/Store/Packaging Thermoforming Finishing Use-as-is Supplier Work Order Update Large Fab Composite NCR No. Action Sign & Description of work order update Initial Root **Chief Eng** Description Date Verification QC Inspector or Non-conformance Step Qty Cause Date Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Ovalized Pressure/Forced Grain Bend Bending Temperature/Cure Over/Under tolerance BOM/Route Hardware Centre Not Concentric to O/S Weld Broken/Damaged Part Incorrect Inspection Incomplete Cracks Wrong Stock Pulled Part Lost/Missing Instructions Incomplete/Unclear Crushed/Crimped Burrs Part Moved Contamination Maintenance Cuffs

Mislabeled

Out of Calibration

Out of Sequence

**Outside Dimensions** 

Misread

Offset

Countersink

Cut Too Short

**Drill Holes** 

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

**Turning Sequence** 

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

February-07-13 8:22:51 AM

Work Order ID: 96829

\*96829\*

Parent Item:

D3876-9

\*D3876-9\*

Parent Item Name: Protector - RH Aft Wall

**Start Date: 2/07/13** 

Required Date: 3/22/13

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

IPP Rev:A 09-01-14 new issue DD verifyed by:EC

Component Item ID/ Item Name

Replacement Mfg/ Item ID Purch Bin Primary Item Location Last Location

Route Seq ID Unit of Measure

sf

Qty on Hand

Qty per Kit

\*\*

Qty

Total

Date Issued Status

MLEXS.125-F60029-04

Purchased

No

100

11.6273

Qtv

Issued

\*MI FXS 125-F60029-04\*

GE PLASTICS LEXAN SHEET

Location MAT019

Loc Qty

11.6273 116273Loc Code

124654

124654

											DQA:	Date	::
NCR:	es/	/ No				WORK ORDER NON-	-CO	NFORM	MANCE / UP	DATE	QA Closed:	Date	2:
						DISPOSITION AGAINS				AGAINST DE	PARTMENT		
Work Orde	er: -		<del></del>			Rework	7		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	do					Scrap	_	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
1 41(1	•0.				<del></del>	Use-as-is	1		noforming	Finishing	4	re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite	]	Supplier	
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	,	or Non-conformance	CI	hief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													İ
Equip/Tooling		•			1							ļ	
Operator							1						İ
Material													
Setup			İ		1								
Other					ļ								
Process				ĺ							-		
Supplier													
Training	Ш				1		1						
Unapproved			ļ	<u> </u>					<u>i                                     </u>				<u> </u>
							FAU	LT CATE	GORY			···	·
Land	ing (	3				General	_	٦		Γ	ا د د د د	Г	`Pressure/Forced
1	$oxed{L}$	Bending			<u> </u>	Bend	$\vdash$	Grain		-	Ovalized	<u> </u>	<b>─</b>
		1	ot Conce	ntric to	O/S	BOM/Route	<u> </u> _	Hardwa		<u> </u>	Over/Under	- H	Temperature/Cure
		Cracks				Broken/Damaged	<u> </u>	<b>⊣</b> `	ion incomplete	<u> </u>	Part Incorre	-	Weld
		Crushed	/Crimped		L	Burrs	<b>L</b>	<b>⊣</b> i	tions Incomplete/	Unclear	Part Lost/M		Wrong Stock Pulled
		Cuffs				Contamination	Ļ	Maintenance			Part Moved		
		Heat Tre	at			Countersink	L	Mislabe		_	Positioned \		<b>–</b>
		Inspection	on Strip in	1 Tube		Cut Too Short		Misrea	d		Power Loss,	'Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Inspection Strip in Tube

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Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	96829
Description: Protector - RH Aft Wall	Part Number:	D3876-9
Inspection Dwg: D3876 Rev: A		Page 1 of 1

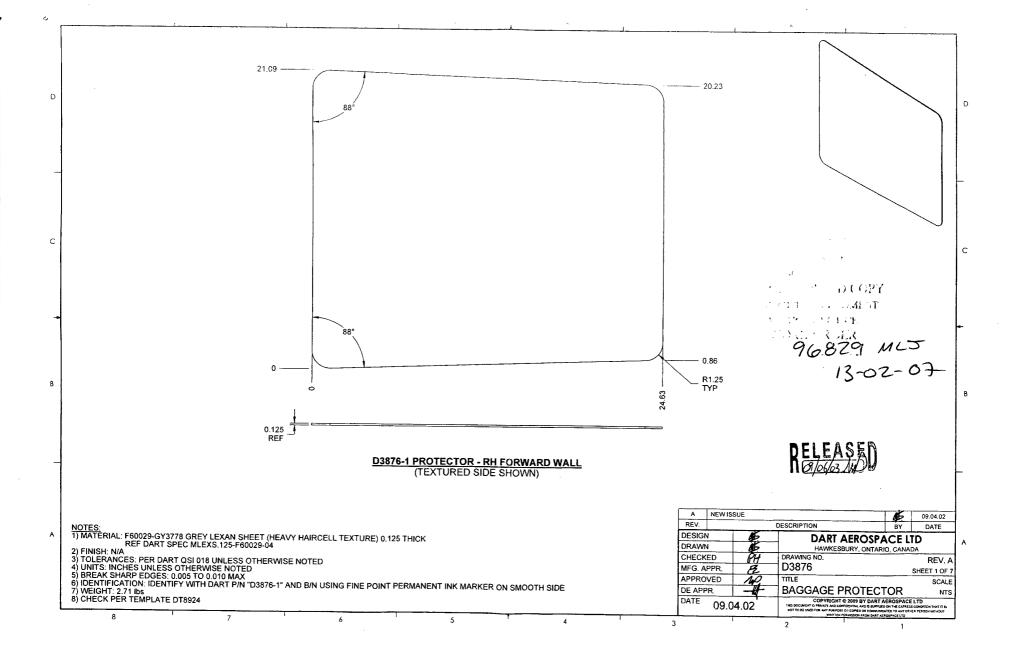
## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.00"	_		V	Thmos
24.25	+/-0.030	24.25	-		<b>T</b>	Jkmoe
16.98	+/-0.030	16.984	-		Τ	
17.77	+/-0.030	13.33	_		+	
11.85	+/-0.030	11.85	_		V	Productor
10.44	+/-0.030	10.444	-		ν	
0.125	+/-0.010	0,126"	-		V	
	*					
			- OAS	47		

Measured by: Jm	Audited by:	9-89	Prototype Approval:	N/A
Date: 13-2-22	Date:	12225	Date:	N/A

	Rev	Date	Change	Revised by	Approved
ĺ	Α	09.06.22	New Issue	KJ ₩	



D С

**D3876-3 PROTECTOR - FORWARD WALL** (TEXTURED SIDE SHOWN)

8

0.35

3.43 -

11.05

18.69

21.22

R15.00

R10.00

R0.250 12 PL

C

NOTES:
1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK REF DART SPEC MLEXS.125-F60029-04

0.125 REF

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3876-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
7) WEIGHT: 2.83 lbs
8) CHECK PER TEMPLATE DT8925

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3876 MFG. APPR. SHEET 2 OF 7 TITLE APPROVED 10 SCALE BAGGAGE PROTECTOR

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THIS DOCUMENT IN PRIVATE AND CONTRICTIVE, AND IS SUMPLED ON THE SUPPLES CONCEIN

NOT 10 BE USED FOR MAY PURPOSE OF CONTRICT FOR WHITE TO DAY OF THE PERFORMANCE TO DE APPR. NTS DATE 09.04.02

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3

25.86

25.

86

21.

